

Date: Wednesday, 09/07/2008 1:20:08 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING
 Job Number : 40404
 Estimate Number : 13456
 P.O. Number :
 This Issue : 09/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-07-09 JLM Verified by:EC

Part Number : ~~D380304~~
 Drawing Number : D3803 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 16/07/2008 Qty: 40 Uln: Each

Handwritten notes: 07407-045, 37, EL 8-7-23

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34075 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3407-5 Ring B40402

EL 8-7-23

2.0 D38031 Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Stem

Batch: 40403

u

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-5 and D3803-1 using welding rod TIG174 as per Dwg D3803 & QSI 004

A/R TIG174 ROD Batch: M101972

EL 8-7-23

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-23

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (37)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 09/07/2008 1:20:08 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 40404

Part Number: D3803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M108523



(37X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45
01-
400
1-15

M-1 08/07/24

Pro

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DS 9418

PC 8/8 (37)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ACTIVE RECALL

08/09

AUTH

DATE

08-08-08

per ECN 08.507

mf 08-08-08

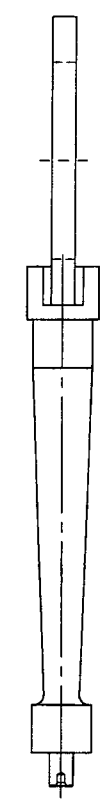
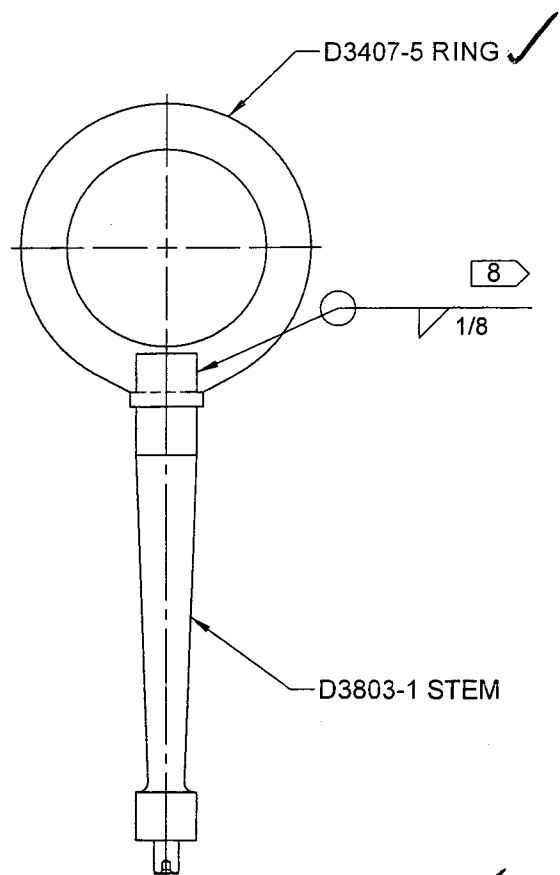
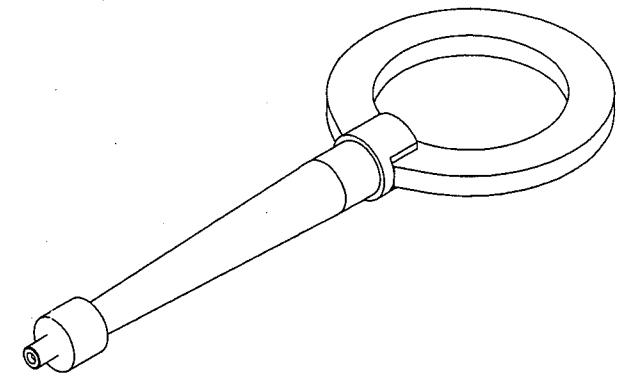
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3407-045 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 08/08/08
 QA: N/C Closed: D Date: 08/08/12

NCR: <u>40404</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/04</u>	<u>#70</u>	During QC3 Powder coat inspection 13 tooling were found to have foreign objects in Beaded in the Powder coat on the Ribs. R.C. objects appear to be either dust or dirt.	<u>[Signature]</u>	Sand all affected areas with 320 grit sand paper.	<u>M.H.</u> <u>08/07/24</u>	<u>[Signature]</u> <u>08/07/24</u>	<u>[Signature]</u> <u>08/07/24</u>	<u>[Signature]</u> <u>08/07/24</u>
				Re Powder coat as per QSI 005.	<u>[Signature]</u> <u>08/07/24</u>			
				Re inspect QC3	<u>[Signature]</u> <u>08/07/24</u>			
			<u>[Signature]</u>	instruct employees to wash with Action Prior to powder coating	<u>[Signature]</u> <u>08/07/24</u>		<u>[Signature]</u> <u>08/07/24</u>	<u>[Signature]</u> <u>08/07/24</u>

NOTE: Date & initial all entries

DESCRIPTION



PRELIMINARY ISSUE
ASS 08.07.09

D3803-041 TOW RING ASSEMBLY
(204/205/212/412)

FINISH: WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNLESS OTHERWISE NOTED
 DIMENSIONS: N/A

REFER TO SI 004 ON ALL EDGES BETWEEN STEM AND RING

REV. A	NEW ISSUE	AJS	08.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3803	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		TOW RING ASSEMBLY	
DATE	08.07.08	(204/205/212/412)	NTS
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